Tuesday, 8/21/2007 3:43:39 PM

¥User:

Kim Johnston

Process Sheet

Customer

: CU-DAR001 Dart Helicopters Services

Job Number

: 34187

Estimate Number

: 12922

P.O. Number This Issue

NA:

: 8/21/2007

S.O. No. : NIA

: SMALL /MED FAB Type

Drawing Number

: D2655UP . D2655 REV B

: RING

Project Number **Drawing Revision**

Drawing Name

Part Number

: N/A ; B

:NLA

Material **Due Date**

: 9/20/2007

Qty:

12 Um:

Each

Written By

Prsht Rev.

First Issue

Previous Run

Checked & Approved By

Comment

: Est Rev:A

New Issue 07-07-04 JLM

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description:

1.0

M1018B400X250



Inventory

Comment: Qty.:

0.2835 f(s)/Unit

Total:

3.4020 f(s)

1018 ASTM A36 .250" thk bar x 4.0"

Batch: M

2.0

WATER JET





Comment: FLOW WATER JET

1-Cut as per Dwg D2655

Dwg Rev:__

Prog Rev:

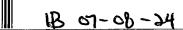
B 07-08-24

2-Deburr if necessary



3.0

QC2



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0

5.0

QC8

SECOND CHECK





Comment: SECOND CHECK

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE





Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Tumble - .030 Radius

2-Deburr any rough edges after tumbling



Page 1

Form: rorocess

Dart Aerospace Ltd	ace Ltd	pa	ros	Ae	Dart	
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W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
		·						
Don't No		DAD #		D- \/	(I) 200		<u> </u>	Malli

Part No:	PAR #:	_ Fault Category:	_ NCR: Yes No DQA:	\bigcirc	Date: 0/09/14
			QA: N/C Closed: _		Date:

	WORK ORDER NON-CONFORMANCE (NCR)							
	Description of NC		Corrective Action	Section B		Varification	Annuaral	A =========
STEP	Section A	Initial Chief Eng	Action Descri Chief Eng	ption	Sign & Date	Section C	Chief Eng	Approval QC Inspecto
·								
							,	
	STEP	STEP Description of NC	STEP Description of NC Section A Initial	STEP Description of NC Section A Initial Action Descri	STEP Description of NC Corrective Action Section B Initial Action Description	STEP Description of NC Corrective Action Section B Initial Action Description Sign &	STEP Description of NC Corrective Action Section B Verification Section C Section A Action Description Sign & Section C	STEP Description of NC Corrective Action Section B Verification Approval Section A Section C Section C Chief Eng

NOTE: Date & initial all entries

Tuesday, 8/21/2007 3:43:39 PM Date: User: Kim Johnston **Process Sheet** Drawing Name: RING Customer: CU-DAR001 Dart Helicopters Services Part Number: D2655UP Job Number: 34187 Job Number: Description: Seq. #: Machine Or Operation: INSPECT WORK TO CURRENT STEP 6.0 QC5 Comment: INSPECT WORK TO CURRENT STEP PACKAGING RESOURCE #1 Comment: PACKAGING RESOURCE #1 A 89.13 12 Identify and Stock Location: FINAL INSPECTION/W/O RELEASE QC21 8.0 Comment: FINAL INSPECTION/W/O RELEASE Job Completion

Dart Aerospace Ltd

W/O:		WORK ORDER CH	HANGES					
DATE	STEP	PROCEDURE CHANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	:	PAR #: Fault Category:	NCF	R: Yes	No DQ	A:	Date:	
				QA:	N/C Close	d:		

NCR:			WORK ORD	ER NON-CONF	DRMANCE	(NCR)			
		Description of NC		Corrective Action	Section B		Verification	A	
DATE	STEP	Section A	Initial Chief Eng	Action Descri Chief Eng	ption	Sign & Date	Section C	Approval Chief Eng	Approval QC Inspector
							,		
		·					-		
					:				

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	34187
Description: Ring	Part Number:	D2655
Inspection Dwg: D2655 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Х	First Article		Prototype
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Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø2.00	+0.012/-0.001	Ø 2.00	×			
Ø0.257	+0.006/-0.001	Ø 3.53	*			
Ø3.00	+0.012/-0.001	\$ 3.00	*			
0.75	+/-0.030	<u>'</u> :75	Xŧ			
						, distributed
		-				

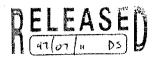
Measured by:	Audited by:	Prototype Approval:	N/A
Date: 07-08-24	Date: 0}/09/04	Date:	N/A

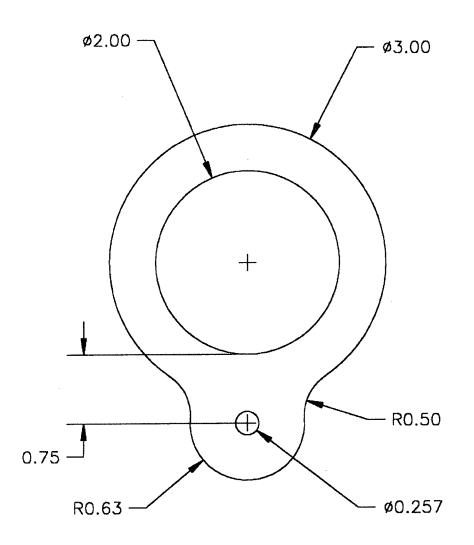
Rev	Date	Change	Revised by	Approv∉d
Α	06.10.12	New Issue	KJ/JLM	





	DESIG	MON	DRAWN BY	DART AEROSPACE USA, INC.
-	CHECK	(ED/	APPROVED	DRAWING NO. REV. B
	5	4	1 4	D2655 SHEET 1 OF 1
	DATE			TITLE SCALE
	97:0	7:07		RING 1:1
	Α		97:03:25	NEW ISSUE
	В		97:07:07	ADD ASTM A36 TO MAT. SPEC.





NOTE: DEBURR ALL SHARP EDGES

MATERIAL: AISI 1018/1020/1025 OR ASTM A36 0.250 THICK FINISH: POWDER COAT PER DART QSI 005 4.3

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED COPY

SHOP COPY RETURN TO **ENGINEERING**

WITHOUT NOTICE

WORK ORDER